

Work Order ID 71928

Wednesday, July 13, 2011 12:52:26 PM



Page 1

Item ID: D4274-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Plate, Fwd Support

Start Date: 7/13/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: *UMF*

Date: *11-07-13* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours
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Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4274	B
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100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: *B*

Prog Rev: *B*

304.178

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

11 07 18 4

11 07 18 4

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Revision ID:

Item Name: Plate, Fwd Support

Start Date: 7/13/2011 Start Qty: 4.00

Required Date: 7/29/2011 Req'd Qty: 4.00

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Approvals: Process Plan: Date:

QC: Date:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Tooling:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



0.00

QC

Memo

Quality Control

130

Identify as per dwg & Stock Location: 139B

0.00



0.00

Packaging

Memo

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



0.00

QC

Memo

Quality Control

40

11/7/18

11/7/20
ME 11-07-20

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Picklist Print

Wednesday, July 13, 2011 12:52:24 PM

Page 1

Work Order ID: 71928

Parent Item: D4274-1

Parent Item Name: Plate. Fwd Support



Start Date: 7/13/2011

Required Date: 7/29/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev:A 10.11.18 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S11GA

Purchased

No

100

sf

89.5000

0.357

1.503158



304/316 0.125 Sheet

ml 11 07 18

Location

Loc Qty

Loc Code

MAT020

89.5

117494

89.5

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DART AEROSPACE LTD		Work Order: 71928
Description: Plate, Fwd Support		Part Number: D4274-1
Inspection Dwg: D4274	Rev: B	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.133	✓		vern	MM-01
Ø0.191	+0.005/-0.001	0.192	✓		vern	MM-01
Ø0.257	+0.006/-0.001	0.258	✓		vern	MM-01
4.40	+/-0.030	4.41	✓		vern	" "
1.40	+/-0.030	1.405	✓		vern	" "
0.335	+/-0.010	0.335	✓		vern	" "
0.750	+/-0.010	0.751	✓		vern	" "
0.380	+/-0.010	0.381	✓		vern	" "
1.30	+/-0.030	1.31	✓		vern	CNC-02
5.70	+/-0.030	5.710	✓		vern	CNC-02
4.35	+/-0.030	4.351	✓		vern	CNC-02
7.11	+/-0.030	7.113	✓		vern	CNC-02
2.80	+/-0.030	2.801	✓		vern	CNC-02
1.75	+/-0.030	1.762	✓		vern	MM-01
1.05	+/-0.030	1.055	✓		vern	MM-01
0.303	+/-0.010	0.303	✓		vern	MM-01
0.375	+/-0.010	0.375	✓		vern	MM-01
0.90	+/-0.030	0.902	✓		H-G	31006
0.75	+/-0.030	0.754	✓		vern	MM-01
0.25	+/-0.030	0.253	✓		H-G	31006
3.000	+/-0.010	3.004	✓		vern	MM-01
1.500	+/-0.010	1.500	✓		vern	MM-01
2.300	+/-0.010	2.300	✓		vern	MM-01
1.20	+/-0.030	1.21	✓		vern	MM-01
1.10	+/-0.030	1.192	✓		vern	MM-01
2.660	+/-0.010	2.669	✓		vern	MM-01
1.330	+/-0.010	1.336	✓		vern	MM-01
0.40	+/-0.030	0.415	✓		vern	MM-01
0.25	+/-0.030	0.26	✓		H-G	31006
1.900	+/-0.010	1.910	✓		vern	MM-01
0.95	+/-0.030	0.955	✓		vern	MM-01

[Signature]
11-07-18

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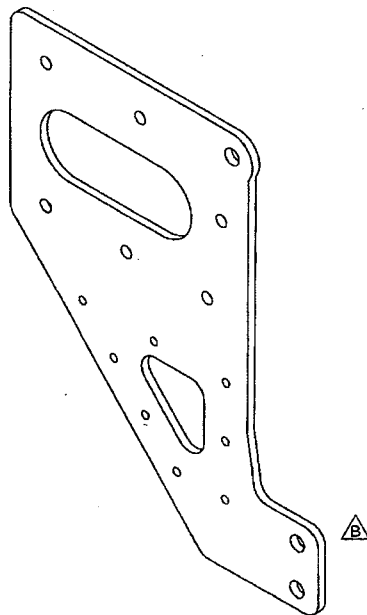
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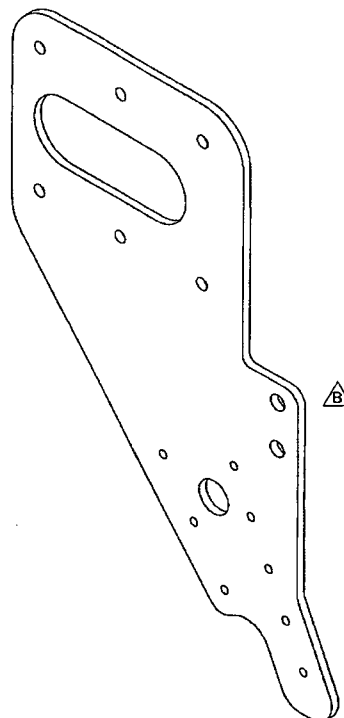
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D4274-1 PLATE, FWD SUPPORT



D4274-3 PLATE, AFT SUPPORT

71928

RELEASED
2010-08-06

B	D4274-1, D4274-3 PLATES LENGTH INCREASED BY 0.25"; HOLES OPENED TO 0.25" FOR AN4 BOLTS	SC	10.12.02
A	NEW ISSUE	SC	10.11.30
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	[Signature]	DRAWING NO.	REV. B
MFG. APPR.	[Signature]	D4274	SHEET 1 OF 3
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	PLATES, BASKET SUPPORT	NTS
DATE	10.12.02	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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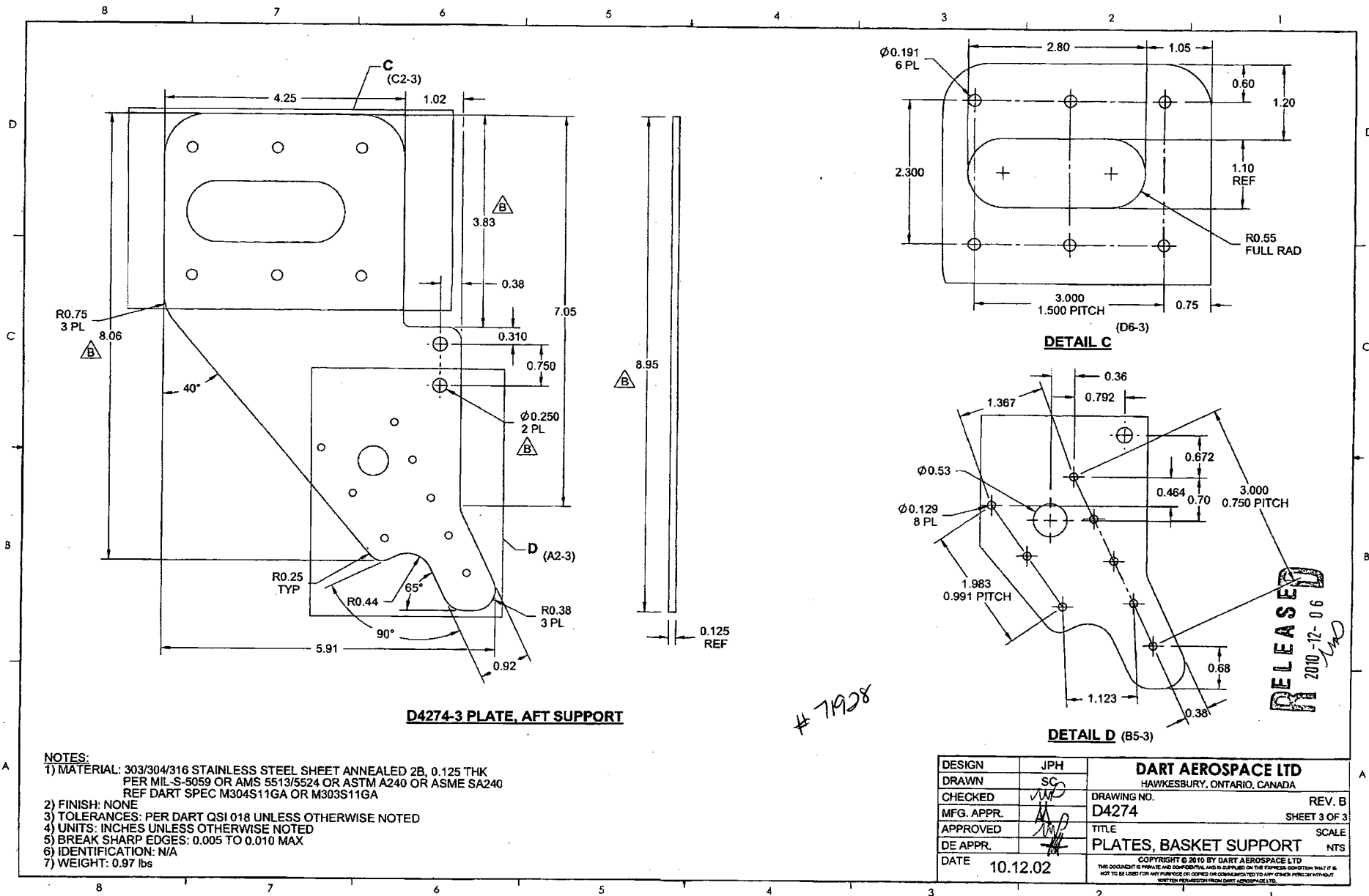
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